



Dart Aerospace Ltd.
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Canada

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D3200-1
Job Sheet 214206



Part No: D3200-1

Job Qty: 16 pcs *24 pcs*

Part Name: Door Post Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/20/20

Job Tracking No:

Due Date: 11/3/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs	11/2/20	11/2/20	0.00	0.15	Bandsaw - 1		ALA
110	HAAS 4 Axis - B4B	16 pcs	11/3/20	11/3/20	0.07	5.26	HAAS - 1 - B4B		<i>NR-500-2 JLA / S.C.L.</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	16 pcs	11/3/20	11/3/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		



Container No: S309306



Part: D3200-1

Job No: 214206

Serial No/Batch: S309306

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 10/29/20

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140 Packaging 3-1 - Stock - B4B 16 pcs <i>24 pcs MTD</i>	11/3/20	0.00 0.00	QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	<i>STP 20-11-01</i>
			QC 8 - 82	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	<i>DAS 28</i>
			Packaging 3 - 7 - B4B	<i>9-89</i>
			Packaging 3 - 8 - B4B	<i>NOV 02 2020</i>
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	<i>DAS 21</i>
150 QC 21 - SA 16 pcs	11/3/20	0.00 0.00	QC 21 - SA - 21	<i>9-89</i>
			QC 21 - SA - 70	<i>NOV 02 2020</i>
			QC 21 - SA - 9	
			QC 21 - SA - 77	
			QC 21 - SA - 28	

Part Op 100 - (Bandsaw) Cut blank: 2.700" x 2.700
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3200-1 as per Folio FA337 and Dwg D3200
 130 - (QC8- Inspect parts - second check)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	.8000 sf (.05 ea)	100-Bandsaw - 1	<i>S154152</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MUHMWB10	1	438	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Post Block	0.196inches + 0.005 - 0.000	0.201 0.196	.198	
2	Door Post Block	0.405inches ± 0.010	0.415 0.395	.406	
3	Door Post Block	100Degrees ± 0	100 100	100	
4	Door Post Block	0.100inches ± 0.010	0.110 0.090	.100	
5	Door Post Block	0.130inches ± 0.010	0.140 0.120	.13	
6	Door Post Block	1.630inches ± 0.005	1.635 1.625	1.628	
7	Door Post Block	0.440inches ± 0.030	0.470 0.410	.435	
8	Door Post Block	2.500inches ± 0.010	2.510 2.490	2.502	
9	Door Post Block	1.845inches ± 0.010	1.855 1.835	1.843	
10	Door Post Block	1.000inches ± 0.010	1.010 0.990	1.00	
11	Door Post Block	1.620inches ± 0.050	1.670 1.570	1.620	
12	Door Post Block	2.500inches ± 0.030	2.530 2.470	2.502	
13	Door Post Block	0.750inches ± 0.030	0.780 0.720	.753	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					